

Work Order ID 68957

Tuesday, April 26, 2011 12:58:37 PM



Page 1

Item ID: D3278-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Support Assembly

Start Date: 4/26/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 4/29/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 4-04-26

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3278	Rev C								
100		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Rivet spacers with support as per Dwg D3278.								
110		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
120		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble support as per Dwg D3278. ***DO NOT TIGHTEN BOLTS*** Identify as D3278-041								

GS 4/04/28 (40)

ccnts

(x40)

GS 4/05/03 (40)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3278-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Support Assembly

Start Date: 4/26/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 4/29/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Sulostoy

Canto
(40)

140



Packaging

Packaging

Identify as per dwg & Stock Location: 5471

0.00

Memo

0.00

GB 11/05/09 (40)

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/5/09

11-05-9
(40)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, April 26, 2011 12:58:43 PM

Page 1

Work Order ID: 68957

Parent Item: D3278-041

Parent Item Name: Support Assembly






Start Date: 4/26/2011

Required Date: 4/29/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: ☐A☐04.04.19☐New issue☐KJ/JLM☐
IPP B 07.08.21 Chg rivet per PAR185 EC Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3278-1  Support		Manufactured	No			100	Each	45.0000	1	40			
<div> <div>Location</div> <div>GA</div> <div>66948</div> <div>67772</div> </div> <div> <div>Loc Qty</div> <div>45</div> <div>4</div> <div>41</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D3278-2  Support		Manufactured	No			100	Each	40.0000	1	40			
<div> <div>Location</div> <div>GA</div> <div>67769</div> </div> <div> <div>Loc Qty</div> <div>40</div> <div>40</div> </div> <div> <div>Loc Code</div> <div></div> </div>													
D3278-3  Spacer		Manufactured	No			100	Each	114.0000	1	40			
<div> <div>Location</div> <div>GA</div> <div>66547</div> <div>68340</div> </div> <div> <div>Loc Qty</div> <div>114</div> <div>4</div> <div>110</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													

EP 11/04/28

EP 11/04/28

EP 11/04/28

4
36

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, April 26, 2011 12:58:44 PM

Page 2

Work Order ID: 68957

Parent Item: D3278-041

Parent Item Name: Support Assembly

Start Date: 4/26/2011

Required Date: 4/29/2011

Start Qty: 40.00

Required Qty: 40.00

MS21042L4

Purchased

No

100

Each

5,256.000

2

80



Nut

Location

Loc Qty

Loc Code

ST300

5256

116188

256

116823

2000

117441

3000

EP 4/05/03

80

AN4-13A

Purchased

No

120

Each

335.0000

2

80



Bolt

Location

Loc Qty

Loc Code

ST357

335

117313

335

EP 4/05/03

80

* AN960JD416

NAS1149D0463J

Purchased

No

120

Each

0.0000

4

160



Washer

D2230-1

Manufactured

No

120

Each

155.0000

2

80



Lug

Location

Loc Qty

Loc Code

ST476

155

65270

2

67396

53

67761

100

EP 4/05/03

EP 4/05/03

2
53
25

Tuesday, April 26, 2011 12:58:44 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

Tuesday, April 26, 2011 12:58:44 PM

Page 3

Work Order ID: 68957

Parent Item: D3278-041

Parent Item Name: Support Assembly

Start Date: 4/26/2011

Required Date: 4/29/2011

Start Qty: 40.00

Required Qty: 40.00

MS20426AD3-6

Purchased

No

120

Each

3,909.000

4

160



Rivet



GS 4/24/28

160

Location

Loc Qty

Loc Code

ST316

3909

105055

339

116289

3570

Tuesday, April 26, 2011 12:58:44 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

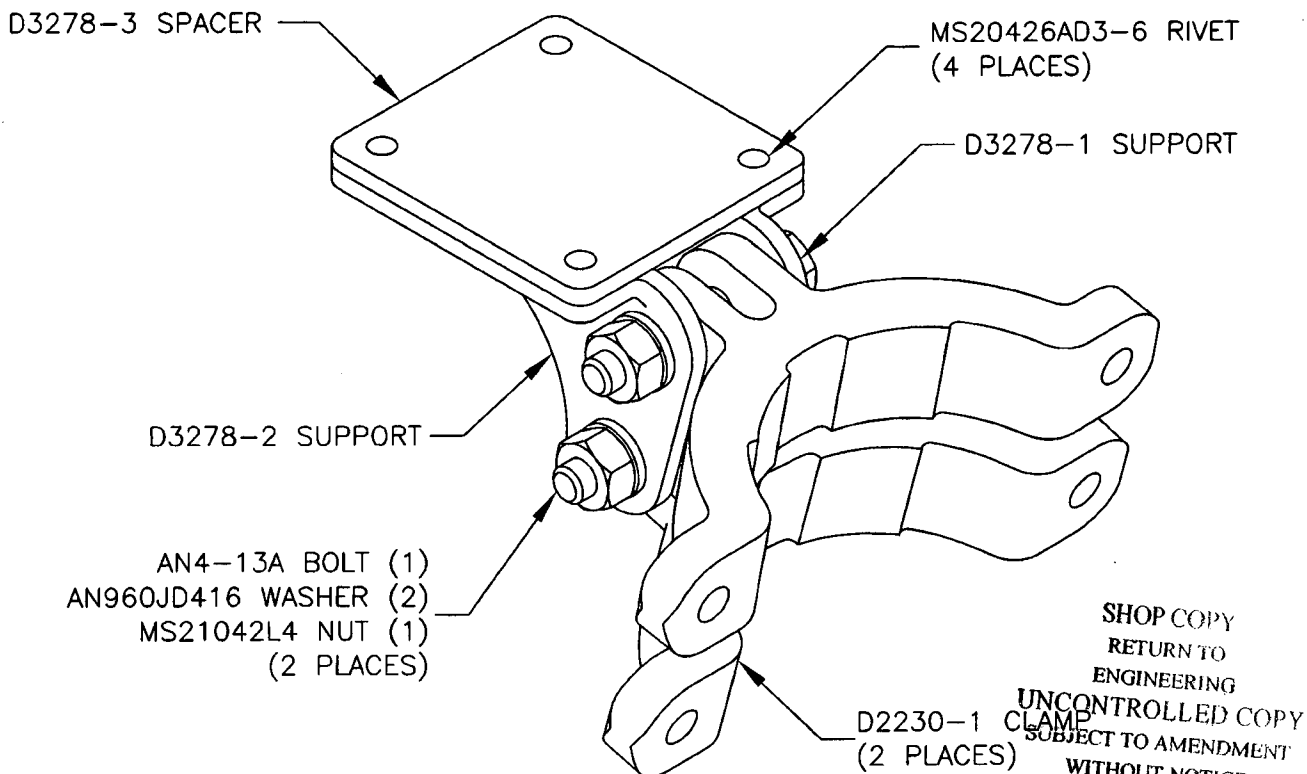
NOTE: Date & initial all entries



DESIGN 91	DRAWN BY BC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07-08-05

D3278-041 SUPPORT ASSEMBLY



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

Qty	Part Number	Description	NO.
X	D3278-041	SUPPORT ASSEMBLY	
2	D2230-1	CLAMP	
1	D3278-1	SUPPORT	
1	D3278-2	SUPPORT	
1	D3278-3	SPACER	
2	AN4-13A	BOLT	
4	AN960JD416	WASHER	
4	MS20426AD3-6	RIVET	
2	MS21042L4	NUT	

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

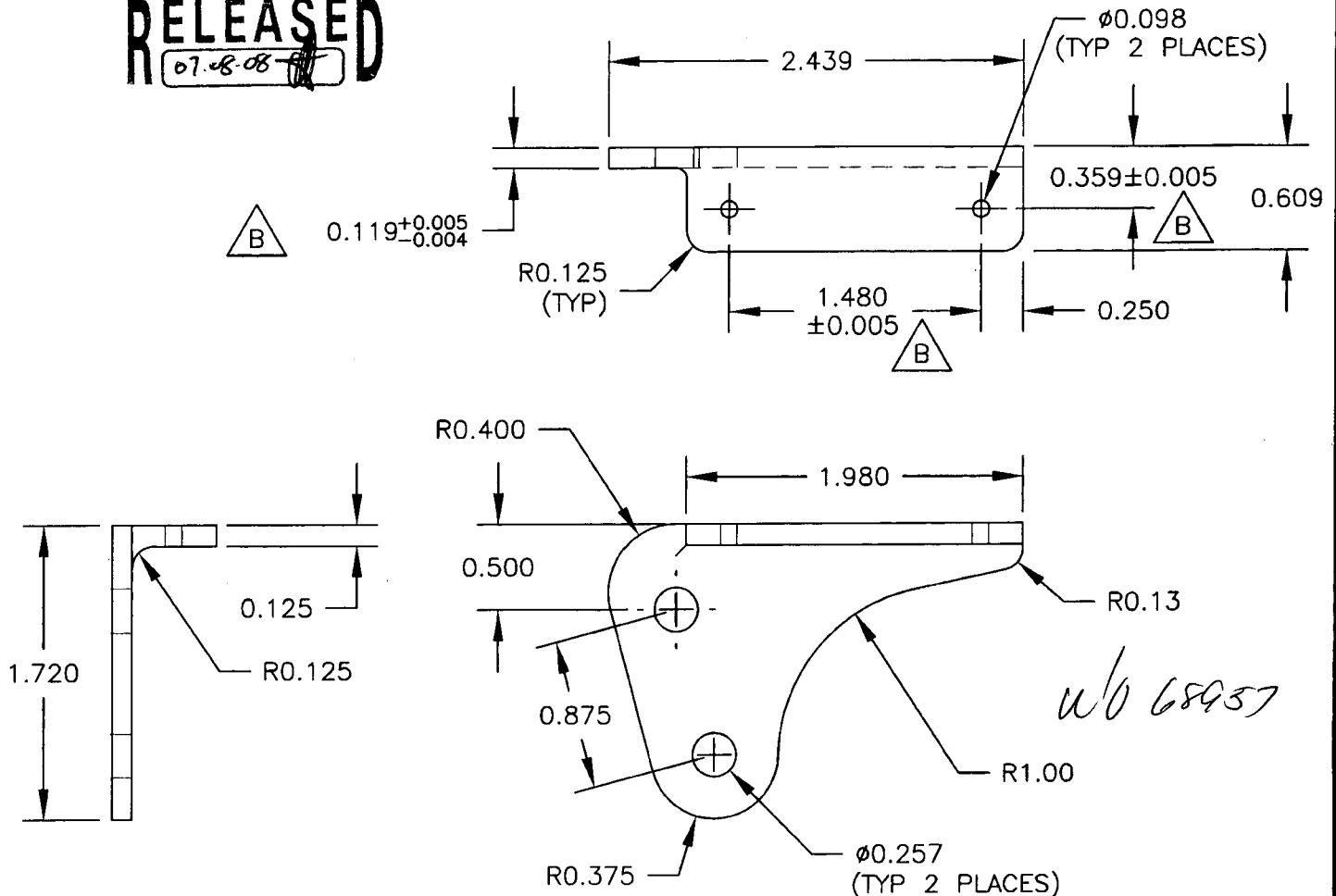
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART

DESIGN <i>92</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07-08-08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPR" T
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

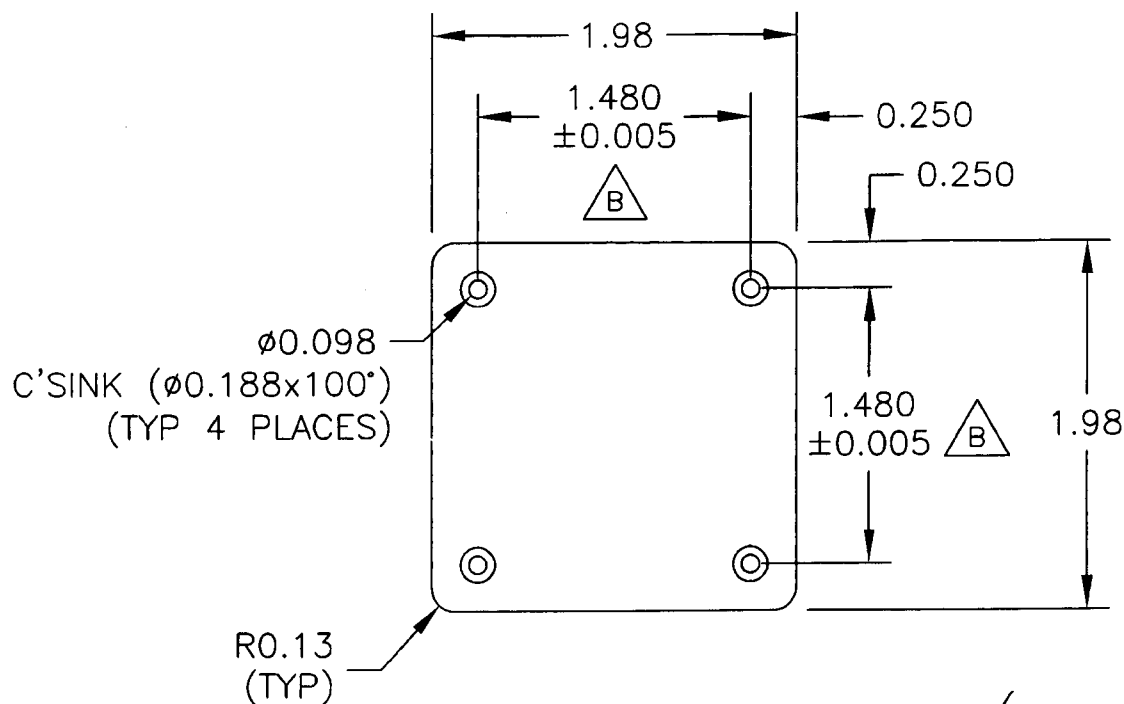
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>GP</i>	DRAWN BY <i>SC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08



u/b 68937

D3278-3 SPACER

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries